

Date: Thursday, 04/06/2009 9:03:29 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT
 Job Number : 48376
 Estimate Number : 12576
 P.O. Number :
 This Issue : 04/06/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D3562041
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3562 REV E
 Previous Run : 47207 Project Number : N/A
 Material :
 Due Date : 11/06/2009 Qty: 1 Um: Each

Written By :
 Checked & Approved By : MF 09-06-04
 Comment : Est Rev:A New Issue 06-11-09 JLM
 Est rev B ECN 987 07.10.09 EC verified by: DD
 Est Rev:C ECN1048 07-12-18 DD verified by:ec
 Est Rev:D 08-07-28 add chemical conversion coat DD
 verified by:EC
 Est Rev:E 09-02-27 (seq13) QC9 to QC10 DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion

346910

Check Material for any Dents or Defects

MF 09-06-04 1

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

MF 09-06-04 1

MF 09-06-04 1

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sorbelot 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/06/2009 9:03:29 AM
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Drawing Name: STEP WELDMENT

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Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PK 09.06.05

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 09-06-08

6.0

D3560041

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

ARM WELDMENT

Batch: *344471*

PK 09.06.10

7.0

D3560043

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

ARM WELDMENT

Batch: *847865*

PK 09.06.10

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total: 32.0000 Each(s)

Blind Rivet

batch: *M111477*

PK 09.06.10

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond *****

A/R Magnabond 6398

Batch: *M1009900*

PK 09.06.10
PK 09.06.10
PK 09.06.10
PK 09.06.10

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 48376

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

850611 (1)

11.0

D2734

Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap

343535

PK 09.06.11

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod *M110130*

2-Grind end cap welds flush as per Dwg D3562

PK 09.06.11

13.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

502/66/12

(FL)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

502/66/12

(040)

(40)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PK 09-06-12

(1)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

X111472

START TIME:

9:30AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

10:00AM

PK 09-06-12 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Seq. #:

Machine Or Operation:

Description :

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: *M111013*

BR 09-06-15 ①

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/06/15 ①

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

SS 09/06/15 ①

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/15 ①

Job Completion



u 09-06-15

